

Work Order ID 81425

81425

Page 1

March-14-12 7:55:52 AM

Item ID: D2873-045 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Nut Plate Assembly
 Start Date: 14/03/2012 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 28/03/2012 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/14 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2873	Rev A

100	BAND SAW	0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks: 1.000" x 0.375" x 2.700" long		SL	12/04/02					

110	HAAS CNC VERTICAL MACHINING #1	0.00							
110									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per Folio FA and Dwg D2873 Identify as D2873-5 Dwg Rev <u>A</u> F1819Folio Rev <u>AA</u>		PO/B.A	12/04/07					

120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control			PO/B.A	12/04/07		20	0		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Revision ID:

Item Name: Nut Plate Assembly

Stop ***NS2***

Start Date: 14/03/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 28/03/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

Re 12.4.9

20 d

140

Small Fab

0.00

140

Small Fab

Memo

0.00

Small Fab

1-Deburr 2- C'sink as per Dwg D2873

20X

12/04/10

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

5/2/04/10

count
+20

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Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: ~~1/1~~ Date: ~~12/03/12~~ Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160									
HandFinish	Memo	0.00							
Hand Finishing									
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	Small Fab	0.00							
180									
Small Fab	Memo	0.00							
Small Fab	1-Assemble as per Dwg D2873 2-Identify as D2873-045								

20 0 BLD 4-10

20x 0 m-f 12/04/10

20x 0 12/04/11

W/O:		WORK ORDER CHANGES					
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Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<i>W</i>	<i>12</i>	<i>04</i>	<i>11</i> (20)
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <i>X-tube ASS'y</i> Memo	0.00 0.00				<i>W</i>	<i>12</i>	<i>04</i>	<i>11</i> (20)
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>12/4/12</i> <i>JS</i>

12-04-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

March-14-12 7:55:57 AM

Page 1

Work Order ID: 81425

Parent Item: D2873-045

Parent Item Name: Nut Plate Assembly

81425

D2873-045

Start Date: 14/03/2012

Required Date: 28/03/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MS21075L5 Purchased No

MS21075L 5

Nut Plate

Location

Loc Qty

Loc Code

ST302

26

120662

26

M6061T6B0.375X01.00
0

Purchased

No

180

f

27.0520

0.225

4.736842

M6061T6B0 375X01 000

6061T6 BAR .375 x 1.00

Location

Loc Qty

Loc Code

MAT001

2.292

118641

2.292

MAT002

24.76

119346

12

120603

0.76

120866

12

MS20426AD4-6

Purchased

No

180

Each

1,962.000

4

80

MS20426AD4-6

Rivet

Location

Loc Qty

Loc Code

ST317

1962

110139

187

118510

853

119436

922

**

EB 12/04/11
26 M12/162 (14x)
SL 12/04/02
4.74
EB 12/04/11
80

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	81425
Description: Radius Block		Part Number:	D2873-5
Inspection Dwg: D2873 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	+/-0.030	2.501	✓		VERN	PHD-01
1.000	+/-0.010	1.000	✓		"	"
0.750	+/-0.010	0.750	✓		"	"
0.250	+/-0.010	0.251	✓		"	"
1.000	+/-0.010	1.000	✓		"	"
2.000	+/-0.010	2.000	✓		"	"
Ø0.128	+0.005/-0.001	0.130	✓		"	"
0.359	+/-0.010	0.360	✓		"	"
Ø0.316	+0.006/-0.001	0.316	✓		"	"
1.000	+/-0.010	1.006	✓		"	"
0.250	+/-0.010	0.247	✓		"	"
0.061	+/-0.010	0.062	✓		"	"
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	0.229 x 0.123	✓		"	"

Measured by: PD/B.A	Audited by: [Signature]	Prototype Approval:	N/A
Date: 12/04/07	Date: 12.4.9	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-045	KJ/JLM [Signature]	[Signature]

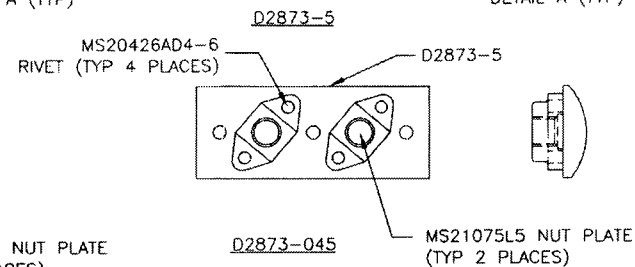
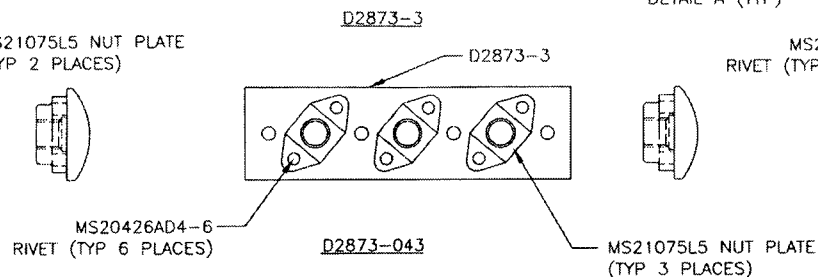
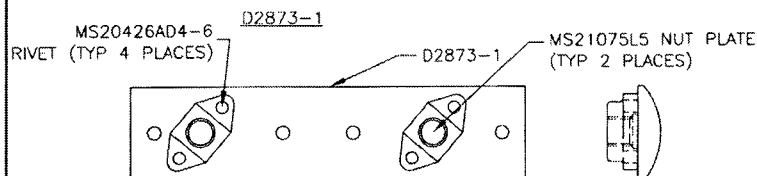
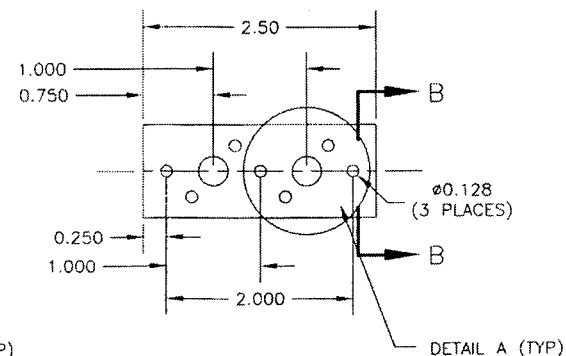
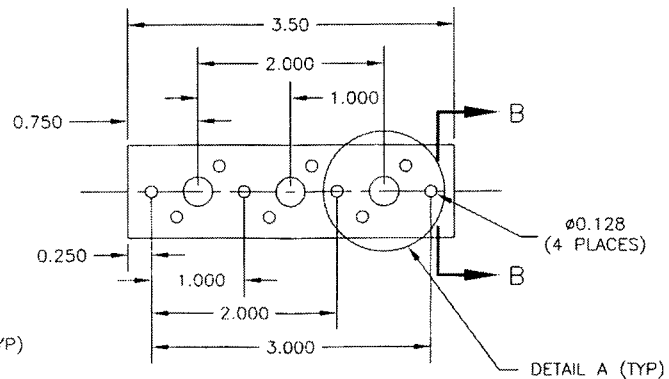
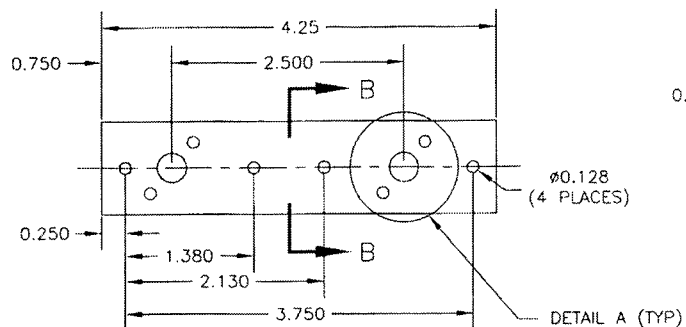
W/O:		WORK ORDER CHANGES					
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D2873-1/-3/-5 RADIUS BLOCK

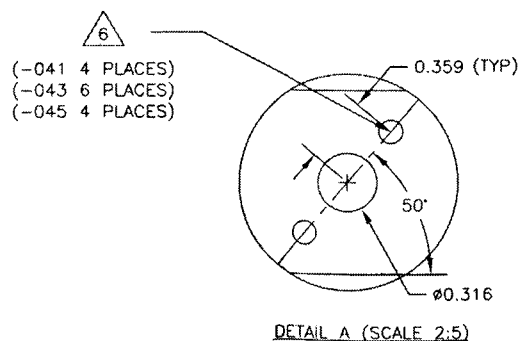
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) $\phi 0.128$ PILOT + C'BORE CURVED SIDE $\phi 0.230 \times 0.125$ DEEP + C'SINK CURVED SIDE $\phi 0.225 \times 100^\circ$

D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

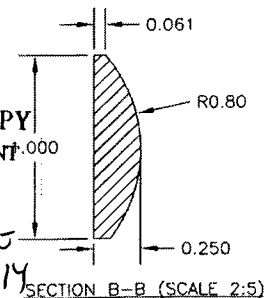
D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81425 MJC

12/03/14



RELEASED
05-07-26

A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE LTD HAMPSHIRE, ONTARIO, CANADA
CHECKED DS	APPROVED DS	DRAWING NO. D2873
DATE 05.07.26		TITLE RADIUS BLOCK
		REV. A SHEET 1 OF 1 SCALE 4:5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries